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Applicant: Pauli Koutonen Date: August 30, 2004
Date Filed: July 13, 2001 Docket No.: FORSAL-16
App. No.: 09/905,550 Art Unit: 3654
For: Method and Apparatus for Examiner: J.Q. Nguyen
Winding a Paper Web

Technology Center 3600

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Brief of Appellants

Technology Center 3600
Commissioner for Patents
P.O. Box 1450
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Dear Sir:

Subsequent to Applicant's Notice of Appeal, dated June 2, 2004, the period for filing being extended one month by an accompanying Petition for Extension of Time, this Appeal Brief is submitted.

1. Real Party In Interest (37 C.F.R. §1.192(c)(1))

This application has been assigned to Metso Paper, Inc. a Finnish corporation having offices at Helsinki, Finland.

2. Related Appeals And Interferences (37 C.F.R. §1.192(c)(2))

There are no related appeals or interferences.

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3. Status of Claims (37 C.F.R. §1.192(c)(3))

The application was filed as a bypass application on July 13, 2001, claiming priority on International Application No. PCT/FI00/00041 having a priority date of January 22, 1999. The bypass application was filed with claims 1–20. On March 11, 2002, all the claims were rejected under 35 U.S.C. §112, and claims 1–5 were rejected as anticipated under 35 U.S.C. section 102 (b), and claims 6–20 were rejected as obvious 35 U.S.C. §103(a). On July 9, 2002, claim 12 was canceled, and the claims were amended. On Aug. 30, 2002, in a Final Action the examiner maintained the rejection of claims 1–5 as anticipated under 102(b) and of claims 6–11 and 13–20 as obvious under §103(a). A telephone interview was conducted on September 13, 2002, (the contents of which were summarized in applicant's response on September 23, 2002) and on September 23 applicant submitted an after final response which revised claim 1 and submitted a new claim (claim 21 based on claims 6 and 20 as discussed during the interview).

In an advisory action mailed September 25, 2002, the examiner refused entry of applicant's after final amendments. On November 25, 2002 applicant further amended the claims and filed a RCE.

On February 5, 2003, in a nonfinal action the examiner rejected claims "1–21" [*sic* 1–11, 13–21]. A phone interview was conducted on April 10, 2003, as recorded in applicant's interview summary filed August 30, 2004, with the Notice of Appeal of the same date.

On July 2, 2003, an amendment was filed and claims 7, 9, 12, 15, and 17 were canceled.

On July 2, 2003, an appeal brief was filed. In response to the Appeal Brief, the application was allowed on September 22, 2003.

On December 11, 2003, applicant filed a RCE and a IDS with new art.

On March 9, 2004, all pending claims were rejected.

On June 2, 2004, applicant filed a Notice of Appeal.

Claims Claims 1–6, 8, 10, 11, 13, 14, 16, and 18–21 remain pending in the

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application.

Claims 7, 9, 12, 15, and 17 are canceled.

Claims 1-6, 8, 10, 11, 13, 14, 16, and 18-21 stand rejected under 103(a) over *Stefanoni* (US 5,217,177) in view of *Shainberg et al.* (US 3,961,547) or *Adami* (US 6,092,452) or *David* (US 3,408,886), or *Stewart et al.* (US 3,587,374).

Claims 1-6, 8, 10, 11, 13, 14, 16, and 18-21 are the subject of this appeal.

4. **Status of Amendments (37 C.F.R. §1.192(c)(4))**

All amendments have been entered.

5. **Summary of the Invention (37 C.F.R. §1.192(c)(5))**

The invention is a method and apparatus for slitting a paper web longitudinally to divide the web into slit webs of desired width in the direction the paper is traveling (p. 1, lines 11-13; p. 2, lines 2-4) while the paper web is produced on a papermaking line, thus eliminating the winder/rewinder equipment conventionally required at the end of the papermaking line (p. 4, lines 24-28). At least two sets of slitting blades are used sequentially one after the other to cut the full width paper web being formed (p. 3, lines 11-15) on the papermaking machine. The first set of blades 15B cuts the web into a first set of widths (p. 4, lines 4-5; p. 7, lines 10-12) which are wound onto cores of first selected widths (p. 4, line 3), and, while the first set of blades is cutting the paper web, a second set of blades 15A are adjusted to widths which are different than the first set of widths (p. 3, lines 11-15; p. 4, lines 4-5; p. 7, lines 23-27). Then all blades 15A, 15B are removed from cutting the paper allowing the paper to be full width for a short time (p. 5, lines 9-11) while the web is cut obliquely across the web (p. 5, lines 22-23). Then the paper web is cut with the second set of blades 15A to a second set of widths (p. 4, lines 9-10) which are wound onto cores (p. 6, line 7) of second selected widths (p. 4, line 3). In this way on-machine slitting is made practical as the papermaking machine does not need to be stopped, nor does the paper need to be sent to the pulper during the change of slit web widths (p. 4, lines 1-4).

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6. **Issues (37 C.F.R. §1.192(c)(6))**

Issue 1. Has the examiner made out a prima facie case of obviousness under U.S.C. 103(a) over *Stefanoni* (US 5,217,177) in view of *Shainberg et al.* (US 3,961,547) or *Adami* (US 6,092,452) or *David* (US 3,408,886), or *Stewart et al.* (US 3,587,374), with respect to claims 1-6, 8, 10, 11, 13, 14, 16, and 18-21?

- A. Has the examiner provided some suggestion of the desirability of doing what the inventor has done? Do the references expressly or impliedly suggest the claimed invention?
- B. Does the examiner present a convincing line of reasoning as to why the artisan would have found the claimed invention to have been obvious in light of the teachings of the references?
- C. Is there teaching or suggestion to make the claimed combination and a reasonable expectation of success which can both be found in the prior art, and not based on applicant's disclosure?
- D. Patentability of claims 3, and 20; claims 6 and 21; claims 18-20; and claims 10, 11-14, 16 argued separately.
- E. Summary of Argument

7. **Grouping of Claims (37 C.F.R. §1.192(c)(7))**

Claims 1-6, 8, 10-11, 13-14, 16, and 18-21 stand rejected on the same grounds (stated in the alternative but applied to all appealed claim) but the claims do *not* stand or fall together.

8. **Argument (37 C.F.R. §1.192(c)(8))**

Discussion of References

Applicant's admitted prior art (AAPA) admits as old a slitter having two winding stations (p. 2, lines 14-15, and 17-18). And applicant admits that the slitter blades in prior art slitters are adjustable (p. 2, lines 20 and 22). And further, applicant admits that in the

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prior art two cutting assemblies which are adjustable have been used as shown in EP Pub. No. 0 308 438 (p. 2, lines 26–27).

Stefanoni (US 5,217,177) is a slitter for making individual rolls of tape from a parent roll. *Stefanoni* discloses two sets of cutting blades which can alternately cut a web one after the other. *Stefanoni* has two sets of blades so that one set may be replaced while the other set is cutting the tape web, thus the machine does not have to be stopped to replace blades that become dull (col. 1, line 6 to col. 2, line 2). Thus *Stefanoni* can change blades without stopping the cutting process.

Because of the arrangement for transitioning from the winding of one spool 44 on one shaft 20, to winding on a new spool 44 on a second shaft 20, the width of the tape being wound cannot change between spools because the slit tape web is momentarily wound on both spools (FIG. 5C). The examiner has not suggested that *Stefanoni* shows or suggests changing tape width without stopping the machine.

In the prior Appeal applicant prevailed over *Stefanoni*, showing that the claims differed over *Stefanoni* by having two sets of cutting blades one of which could be adjusted while the other was cutting the web. The newly applied references are directed to corrugated board slitting machines which disclose that it is old in a corrugated board slitting machine to have two sets of cutting blades wherein one set of cutting blades is adjusted to a different width while the first set is cutting a web.

The New Art

The new art *Shainberg et al.* (US 3,961,547), *Adami* (US 6,092,452), *David* (US 3,408,886), and *Stewart et al.* (US 3,587,374) are each from the art directed to corrugated board or corrugated board used to make cardboard boxes. Although the references are not limited to corrugated board, this is the context of their teaching. It is admitted that in the corrugated board art it has long been known to have two sets of cutting blades, one of which is adjusted while the other is cutting. *The Pulp & Paper Dictionary* by John R. Lavigne (1993 Miller Freeman Book, San Francisco) p.123, defines *corrugated board* as “(1) A pasted, single- or double-faced, multi-layered type of board in which the bottom or middle layer is

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fluted." Corrugated board machines typically run at web speeds of 60–250 meters/minute, whereas modern papermaking machine typically operate at 1,000 to 2,000 meters per minute. Machines for handling Corrugatedboard are typically directed to forming boxes, where the size of the boxes changes frequently, motivating a rapid change in the slitting of the Corrugatedboard to different widths. Applicant's invention is not a Corrugatedboard machine, but part of a papermaking machine which is directed to making rolls of paper.

The claims continue to define a patentable invention inasmuch as the new art does not show a *papermaking* machine wherein two sets of cutting blades alternately slit the web into different widths, wherein one set of blades is adjusted while the other set of blades is cutting the web. The claims variously differentiate over the prior art by having a full width web between changing of slitting blades, and by having two sets of winding cores, and further applying glue to the full web width. These limitations distinguish over the applied art which does not disclose the formation of *rolls*, and therefore does not suggest forming a full width web to which glue or adhesive is applied.

The difference between the prior art of record, particularly applicant's admitted prior art, *Stefanoni, Shainberg et al.* (US 3,961,547), *Adami* (US 6,092,452), *David* (US 3,408,886), and *Stewart et al.* (US 3,587,374) and applicant's claimed invention, is that the prior art does not show cutting a paper web in a *papermaking line* with a first set of cutting blades, while simultaneously adjusting the width of a second set of cutting blades, cutting the web in the cross machine direction with a web-severing device followed by cutting with the second set of blades. Nor does the art of record show a slitter with two sets of adjustable slitting blades and two winding stations with different spool/core widths.

- A. **Has the examiner provided some suggestion within the prior art of the desirability of doing what the inventor has done? Do the references expressly or impliedly suggest the claimed invention?**

In the Office Action dated March 9, 2004, from which this Appeal is taken, the examiner makes his case for obviousness by stating on p. 2, line 15 to p. 3 line1:

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Stefanoni discloses a winding apparatus with slitting means including two sets of blades; each set alternatively used in slitting while the other set is not operational. Shainberg et al, Adami, David, or Stewart all discloses slitting devices having at least two sets of slitters disposed in succession, with one set of slitters performing slitting while the other set is non-operational and in a position so that the slitting blades can be adjusted. It would have been obvious to a person having ordinary skill in the art to adjust the non-operational slitting blades in the apparatus of Stefanoni as taught by Shainberg et al, Adami, David, or Stewart or to alternatively provide the apparatus of Stefanoni with slitting devices as taught by Shainberg et al, Adami, David, or Stewart so that the non-operational slitting blades can be adjusted.

This statement makes clear that the examiner does not find the suggestion to do what applicant has done in the art of record. Rather the examiner bases his rejection on a supposition of what a person of ordinary skill in the art would know.

B. Does the Examiner present a convincing line of reasoning as to why the artisan would have found the claimed invention to have been obvious in light of the teachings of the references?

Because the examiner has not found within the references a suggestion for doing what the inventor has done, nor any suggestions within the references for the combining of the references, the examiner must present a convincing line of reasoning as to why the artisan would have found the claimed invention to be obvious in light of the teaching of the references. The examiner on p. 3, lines 6-7 states that, "Claims 3 and 20 are deemed an obvious step to one of ordinary skill in the art since it is not feasible or logical to slit an already slit web." This reasoning relates only to dependent claims 3 and 20 and the limitation

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“produce a desired length of full-width web”. It is contradicted by *Adami* in which FIGS. 1, 2, and 6 show slits which stop and start at the same machine direction point, or are continued through a change in slitter width. The figures of *Adami* show there is no logical necessity that all slitters be removed and the web allowed to run full width for a period of time. The examiner reasons (apparently with respect to claims 10 and 18) that “The provision of cores having widths to accord [with] the widths of the slit webs would have been obvious to a person having ordinary skill in the art to properly wind the slit webs....” March 9, 2004 action, p. 3, lines 7–9. Here, the examiner’s logic presumes applicant’s claimed invention i.e., that the web is cut to different widths, but does not supply a motivation for it or expectation of success that the slitter of *Stefanoni* can be combined with *Shainberg et al.* (US 3,961,547), *Adami* (US 6,092,452), *David* (US 3,408,886), or *Stewart et al.* (US 3,587,374) to produce applicant’s claimed invention.

C. Is there a teaching of a suggestion to make the claimed combination and the reasonable expectation of success which can both be found in the prior art, and not based on applicant’s disclosure?

To properly perform the obviousness analysis, the person of ordinary skill must be placed at the time of the invention and be unaware of applicant’s solution. It is from this vantage point, and only this vantage point, where the analysis starts. From there it is incumbent upon the examiner to provide convincing reasoning why the artisan would have found the claimed invention obvious. And more particularly, how the suggestion or motivation, and an expectation of success for combining references is also found within the prior art.

In *Sensonics Inc. v. Aerosonic Corp.*, 38 USPQ2d 1551, 1554 (Fed. Cir. 1996) the Court agreed with the trial court that the references did not render the invention obvious stating:

There is no teaching or suggestion whereby a person of ordinary skill would have been led to select these mechanical

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and electrical structures and concepts and combine them as did DeMayo in the '114 invention. To draw on hindsight knowledge of the patented invention, when the prior art does not contain or suggest that knowledge, is to use the invention as a template for its own reconstruction – an illogical and inappropriate process by which to determine patentability. *W.L. Gore & Assoc. v. Garlock, Inc.*, 721 F.2d 1540, 1553, 220 USPQ 303, 312-13 (Fed. Cir. 1983). The invention must be viewed not after the blueprint has been drawn by the inventor, but as it would have been perceived in the state of the art that existed at the time the invention was made. *Interconnect Planning Corp. v. Feil*, 774 F.2d 1132, 1138, 227 USPQ 543, 547 (Fed. Cir. 1985).

The Examiner has not made a legally sufficient argument for how a person of ordinary skill in the art at the time of the invention would have found the claimed invention obvious in view of *Stefanoni* and *Shainberg et al.*, *Adami, David*, or *Stewart et al.* On the contrary, applicant has set out above distinctions between the claimed invention and the references, which the person of ordinary skill is not in possession of without the applicant's disclosure as a blueprint.

D. Limitations which in combination provide a separate grounds for patentability so that the claims do not all stand or fall together.

Claims 3, 6, 20 and 21 are separately patentable because they add the step of forming a full width web, and claims 6 and 21 are further patentable by the limitation of applying glue to the full width web. This step of forming a full width web between two sets of slits is unique, and applying glue to the full width web more so, in the context of applicant's process and further defines the process of how the transition is made from the slits of first widths to slits of second widths. The examiner has asserted (page 3 lines 1–3 of the Office Communication of March 9, 2004) “that steps in winding such as application of glue/adhesive for affixing the ends of the web, passing the web via a drawing nip, and using a flying splice/change unwinder are old and well known in the art” to which applicant agrees. The examiner further asserts (page 3, lines 4–5) “and the use of such would have been

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obvious to a person having ordinary skill in the art to obtain the same function." For which proposition the examiner has not provided a suggestion or a motivation, and an expectation of success.

Claims 18-20 are method claims and are separately patentable because in addition to including the limitation on adjusting a second slitter assembly while a first slitter assembly is operating, also include roll cores of first selected widths and second selected widths. Although the prior art teaches having two winder stations, which could have roll centers/cores of different widths, this limitation clearly differentiates over *Stefanoni* in which all the roll cores are the same and over *Shainberg et al.*, *Adami, David*, or *Stewart et al.* where roll cores are not suggested. Thus although the parts are known, the prior art does not teach the combination of roll centers/cores of first widths and second widths as described in claims 18-20 thus further distinguishing over the art of record.

Claims 10, 11-14, and 16 are to an apparatus and are separately patentable, the apparatus having a first adjustable slitter assembly, and a second adjustable slitter assembly of widths different than the first slitter assembly, and in addition a first winder station with roll centers of first width, and a second winder station with roll centers of second widths. The apparatus claims can not use as a limitation the process limitation of adjusting one slitter assembly while the other is cutting. However the combination of having two adjustable slitter assemblies which are set to different widths and two sets of roll centers which correspond to the different widths of the slitter assemblies distinguish over the art of record.

E. Summary of Argument

Progress in the papermaking art may be characterized as faster webs, wider webs, higher-quality paper, and completion of more steps of finishing or converting, on the same machine on which the paper itself is manufactured. Many steps in converting paper into the final saleable product, such as calendering, coating, or slitting, have in the past been performed after the paper has first been wound on a large machine reel on the papermaking machine. Recently, more coating and calendering has been done on the papermaking

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machine before the web is reeled up. Applicant's invention is an arrangement of a slitter on a papermaking machine. Papermaking machines are run continuously day and night. They have capital costs which can be in the hundreds of millions of dollars, and any downtime has a large cost. The claimed slitter continuously processes paper into different sets i.e., rolls of different widths, in such a way that no paper is wasted, and the process can be continuous at the speed of the papermaking machine. The key problem addressed by the invention is the transition to different slitting widths, and different winding cores so as to avoid shutting down the papermaking machine, or wasting paper, when the widths of the paper rolls (sets) being formed are changed. The examiner does not maintain the invention claimed by applicant is known.

The prior art *Stefanoni* is a converting machine for converting a roll of paper/tape into a plurality of rolls of tape, *Stefanoni* has an arrangement whereby two sets of cutting knives set to the same widths can be interchanged so the machine need not be stopped while the knife blades are being replaced. However, applicant introduced extrinsic evidence by way of Exhibit A attached to applicant's amendment filed July 9, 2002, from the web site of the assignee of the *Stefanoni* patent. Exhibit A shows a device similar or identical to the device disclosed in *Stefanoni* in which the blades are described as adjustable, and in which it is stated that the "TIME NEEDED FOR SIZE CHANGEOVER... [is] 10 minutes" Exhibit A, p. 1. This characterization of *Stefanoni*, as not showing a change in blade position while the web is moving, is not disputed by the examiner. Clearly *Stefanoni* does not address the problem addressed by applicant's invention.

The new art *Shainberg et al.*, *Adami, David*, and *Stewart et al.*, are in a somewhat related, but distinct art, directed to Corrugatedboard such as used to make cardboard boxes. In processing Corrugatedboard it is apparently well known to use several sets of slitter and scoring knives, wherein one set can be adjusted while the other is in operation. The examiner does not maintaining the applicant's claims read on this newly applied art. Each of the prior art references *Shainberg et al.*, *Adami, David*, and *Stewart et al.*, must be read as a whole, and each is clearly directed to slitting and scoring/creasing Corrugatedboard (i.e. a pasted, single-

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or double-faced, multi-layered type of board in which the bottom or middle layer is fluted) preparatory to forming cardboard boxes and the like. Single faced Corrugatedboard can be wound into rolls, but even this is not suggested in combination with the apparatuses of *Shainberg et al.*, *Adami, David*, and *Stewart et al.* The radical differences between Corrugatedboard and a paper web continuously formed on the papermaking machine is such that the examiner must do more than simply identify similar structures using applicant's claims as a blueprint to select features which are combined to produce applicant's invention.

The preamble of the claims breathes life and breath into the claims to clearly distinguish over *Shainberg et al.*, *Adami, David*, and *Stewart et al.* directed to Corrugatedboard. Form the specification:

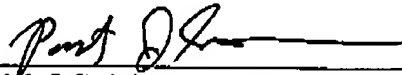
[0014] The method and apparatus according to the invention are particularly suitable for use in papermaking lines, where the web is passed directly from the papermaking machine to the winding station of customer rolls thus disposing with the winder/rewinder equipment conventionally required at the end of a papermaking line. In the present system, the papermaking machine is provided with a drawing nip that precedes the apparatus according to the invention, whereby the nip is immediately followed by the slitter assemblies, the web severing means and the winding stations.

The dependent claims are argued separately and add features which further distinguish over devices used to process Corrugatedboard. In particular, the process where the web is slit to one set of widths, and then run full width before cutting the web in the cross machine direction, and applying glue across the entire web followed by slitting to different widths is completely alien to *Shainberg et al.*, *Adami, David*, or *Stewart et al.*

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In view of the Examiner's failure to make out a prima facie showing of obviousness, and the failure of the art of record to provide a suggestion or expectation that applicant's invention can be successfully constructed from the known structures, it is respectfully requested that the Examiner's rejection of the appealed claims be overruled.

Respectfully submitted,



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Appendix (37 C.F.R. §1.192(c)(9))

The following claims are on appeal:

1. A method for winding and slitting a paper web in a papermaking line, comprising the steps of:

dividing a web longitudinally into a plurality of slit webs of first selected widths;

winding the slit webs about roll centers, to form rolls at a winding station;

periodically cutting the web in a cross machine direction with a web-severing device

in conjunction with a roll set change on the winding station, wherein the

improvement comprising:

slitting the web with a first slitter assembly adjusted to the first selected widths, while

a second slitter assembly is adjusted into second selected slitting width

positions which are different than the first selected widths, followed by cutting

the web in the cross machine direction with the web-severing device, followed

by slitting the web with the second slitter assembly, while the first slitter

assembly is adjusted into alternative selected slitting width positions.
2. The method of claim 1, wherein in the first slitting assembly and the second
slitting assembly are disposed in succession along the travel direction of the web.

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3. The method of claim 1 wherein, during the roll set change of the winding operation, the first slitter assembly is driven into an open position in order to produce a desired length of full-width web, after which the second slitter assembly is driven into a slitting position in order to divide the web into slit webs.

4. The method of claim 3 wherein the periodic cutting of the web in the cross machine direction is obliquely to the web travel direction at an area of the desired length of full-width web.

5. The method of claim 1 wherein, prior to the roll set change at a first winding station, the slit webs are wound into finished rolls and a second winding station is prepared for winding by inserting new roll centers in place and driving the winding station to a synchronous speed with the speed of the web.

6. The method of claim 1 wherein, the step of periodically cutting the web includes the operation of using the web-severing device to apply glue or similar adhesive to an area of the full-width length of the web, close to the severing point of the web, in order to attach a tail of the web to the roll centers at the winding station.

8. The method of claim 1, wherein the web is passed from the papermaking machine to the winding station via a drawing nip formed by two rolls.

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10. An apparatus in a papermaking line for slitting and winding a paper web comprising:

a paper web, defining a direction of travel, extending through a first adjustable slitter assembly set to produce a plurality of first slit webs of first selected widths, a second adjustable slitter assembly set to produce a plurality of second slit webs of second selected widths, which differ from the first selected widths, a web-severing device, and a first winder station having a first plurality of roll centers corresponding to the first slit webs of the first selected widths and a second winder station having a second plurality of roll centers corresponding to the second slit webs of the second selected widths, the first winder station and the second winder station being arranged to alternate so as to receive corresponding first slit webs of the first selected widths on the first plurality of roll centers in the first winder station and second slit webs of the second selected widths on the second plurality of roll centers in the second winder station, wherein the first adjustable slitter assembly and the second adjustable slitter assembly are arranged to alternate in cutting the web, and each of the first slitter assembly, and the second slitter assembly being adjustable, when not cutting the web, to vary the web slit widths.

11. The apparatus of claim 10, wherein the first adjustable slitter assembly and the second adjustable slitter assembly are disposed in succession along the travel direction of the web.

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13. The apparatus of claim 10, wherein said web-severing device is adapted to cut the web obliquely to the web travel direction.

14. The apparatus of claim 10, wherein said web-severing device includes means for applying glue or similar adhesive close to a severing point of the web in order to attach a tail of the web to the roll centers.

16. The apparatus of claim 10, further comprising a drawing nip for passing the web from the preceding apparatus to the first adjustable slitter assembly and the second adjustable slitter assembly, the drawing nip for keeping a proper tension of the running web at the web's delivery from said preceding processing step.

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18. A method for winding and slitting a paper web in a papermaking line, comprising the steps of:

alternately slitting a moving web, which defines a travel direction, with a first slitter assembly to divide the web longitudinally into a first plurality of slit webs of first selected widths, and winding said first plurality of slit webs onto a first plurality of winding cores of first selected widths, and simultaneously adjusting a second slitter assembly into a second selected slitting width position followed by;

cutting the web in the cross machine direction with a web-severing device in conjunction with a roll set change on a winding station which receives the web from the slitter assemblies, followed by slitting the web with the second slitter assembly and winding said second plurality of slit webs onto a second plurality of winding cores of second selected widths.

19. The method of claim 18 wherein the first slitting assembly and the second slitting assembly are disposed in succession along the travel direction of the web.

20. The method of claim 18 wherein, during the roll set change of the winding operation, the first slitter assembly is driven into an open position in order to produce a desired length of full-width web, after which the second slitter assembly is driven into a slitting position in order to divide the web into slit webs.

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21. A method for winding and slitting a paper web in a papermaking line, comprising the steps of:

- dividing a web longitudinally into a plurality of slit webs of first selected widths;
- winding the slit webs about roll centers, to form rolls at a winding station;
- periodically cutting the web in a cross machine direction with a web-severing device in conjunction with a roll set change on the winding station, wherein the improvement comprises:
 - slitting the web with a first slitter assembly adjusted to the first selected widths, while a second slitter assembly is adjusted into second selected slitting width positions which are different than the first selected widths, followed by cutting the web in the cross machine direction with the web-severing device, followed by slitting the web with the second slitter assembly, while the first slitter assembly is adjusted into alternative selected slitting width positions; and
 - wherein, during the roll set change of the winding operation, the first slitter assembly is driven into an open position in order to produce a desired length of full-width web followed by the step of using the web-severing device to apply glue or similar adhesive to an area of the full-width web, after which the second slitter assembly is driven into a slitting position in order to divide the web into slit webs.